

Work Order ID 150117

Wednesday, August 24, 2016 11:35:12 AM

150117

Page 1

Item ID: 647.1402 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lower Cutter Assembly
 Start Date: 8/19/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/24/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: AUG 24 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.1400	B								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Small Fab	Memo	0.02							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.								
	A/R RTV LOCTITE 598: <u>135479</u>								
	exp. date: <u>04/18</u>								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

SEP 27 2016

DAS
6
9-89

1X

DAS
36
9-89
16/09/27

DAS
38
9-89

SEP 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY																																																																																																																											
Environment	☐	Design	☐	Doc/Data	☐	Equip/Tooling	☐	Handling/Pre	☐	Material	☐	Internal Transport	☐	Tribal Knowledge	☐	LOA	☐	Substation	☐	Past Expiry Date	☐	Misidentified	☐	No Re-verification	☐	Operator	☐	Offset/Setup	☐	Supplier	☐	Training	☐	Use for Testing	☐	Poor Information	☐	Rushing	☐	Product Improvement	☐	Process Improvement	☐	Manufacturing Process	☐	Past Due	☐	Pressure/Forced	☐	Bending	☐	Centre Not Concentric	☐	Cracks	☐	Crimp/Kink/Ripple/Wave	☐	Cuffs	☐	Crushing	☐	Heat Treat	☐	Wave/Twist in Tube	☐	Marks/Chatter	☐	Temperature/Cure	☐	Set-up	☐	BOM/Route	☐	Broken/Damage/Defect	☐	Inspection Incomplete/Unqualified	☐	Contamination	☐	Countersink	☐	Cut Too Short	☐	Instructions Incomplete/Unclear	☐	Drill Holes	☐	Power Loss/Surge	☐	Folio/Program	☐	Grain	☐	Weld	☐	Wrong Stock Pulled	☐	Out of Sequence	☐	Off-set	☐	Mislabeled	☐	Fit/Function	☐	Misaligned/off center	☐	Positioned Wrong	☐	Outside Dimensions	☐	Over/Under tolerance	☐	Part Incorrect	☐	Part Lost/Missing	☐	Part Moved	☐	Drawing	☐	Finish	☐	Misread	☐	Turning Sequence	☐
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Page 2

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N900040100

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NS1

Revision ID:

Stop

NS2

Item Name: Lower Cutter Assembly

Start Date: 8/19/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: OCK046 0.00***140***

Packaging

Memo

0.00

Packaging

***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND
REV***

1

DAS
6
9-89

SEP 2 8 2016

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.02

Quality Control

DAS
21
9-89

SEP 3 0 2016

DAS
21
9-89

SEP 2 9 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

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150117

Parent Item: 647.1402

647 1402

Parent Item Name: Lower Cutter Assembly

Start Date: 8/19/2016

Required Date: 8/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701 *646 9701* Cutter Sub Assembly		Manufactured	No				Each	4.0000	**	1 <i>14535</i>			DAS 6 9-89

Location Loc Qty Loc Code

cck012

4

145346

4

NAS1149FN832P

Purchased

No

Each

1,884.000

6

NAS1149FN832P

Washer

**

135603

DAS
6
9-89

Location Loc Qty Loc Code

GA

1705

M133316

16

M133769

89

M135058

1600

ST263

179

M134257

179

MS27039-08-19

Purchased

No

Each

411.0000

3

MS27039-08-19

Screw

**

135539

DAS
6
9-89

Location Loc Qty Loc Code

GA

232

m132930

84

m133077

22

m134063

64

m135046

62

ST277

179

m135408

79

m135466

100

SEP 27 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Page 2

Work Order ID: 150117

150117

Parent Item: 647.1402

647 1402

Parent Item Name: Lower Cutter Assembly

Start Date: 8/19/2016

Required Date: 8/24/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

Each

946.0000

3

MS21042L 08

Nut

**

135536

DAS
6
9-89

Location

Loc Qty

Loc Code

CCK003

125

m135408

125

GA

131

m134063

131

ST303

690

m133922

37

m135046

153

m135133

100

m135274

100

m135466

300

647.1501

Manufactured

No

Each

2.0000

1

647 1501

Lower Deflector Assembly

**

DAS
6
9-89

Location

Loc Qty

Loc Code

CCK002

2

140918

2

SEP 27 2016

Wednesday, August 24, 2016 11:35:15 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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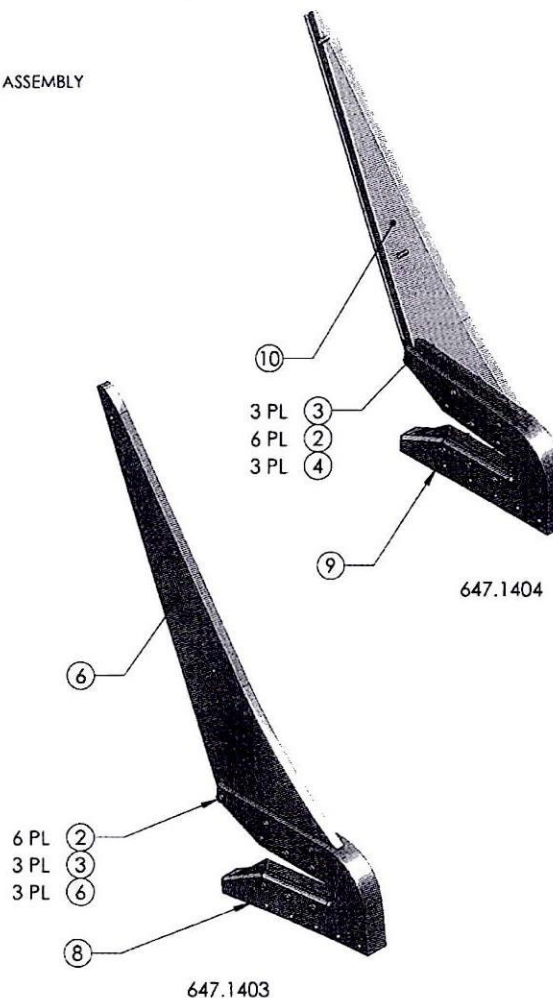
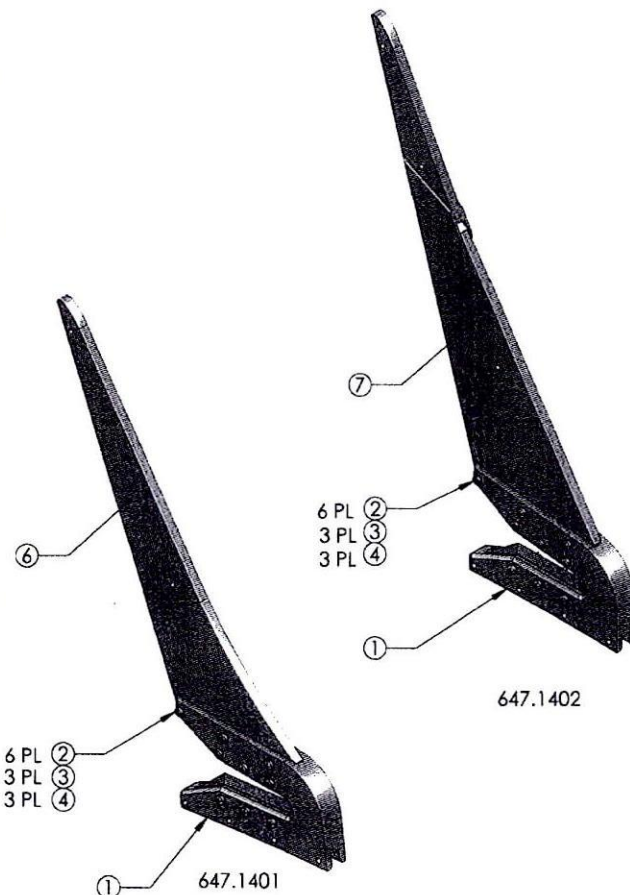
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NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 6, & 7 UPON ASSEMBLY

REV	DESCRIPTION	DATE	APPROVED
1	LAST PROFORME REVISION: PPT		INC
INC	INITIAL RELEASE	06/15/09	P. BRAVO
A	INCORPORATED ECH'S 02943 & 03911	06/07/13	P. BRAVO
B	INCORPORATED ECH'S 05336	02/28/16	P. BRAVO

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150117 INC
160824



1				10	647.1513	UPPER DEFLECTOR		
1				9	646.9703	CUTTER SUB ASSY		
	1			8	646.9702	CUTTER SUB ASSY		
		1		7	647.1501	LOWER DEFLECTOR ASSY		
	1		1	6	647.1510	UPPER DEFLECTOR		
A/R	A/R	A/R	A/R	5	601.2045	RTV, LOCTITE 598		
3	3	3	3	4	601.1541	NUT	MS21042L08	
3	3	3	3	3	601.2765	SCREW	MS27039-0819	
6	6	6	6	2	601.2764	WASHER	NAS1149FN832P	
		1	1	1	646.9701	CUTTER SUB ASSY		
X					647.1404	CUTTER ASSY (UPPER)		
	X				647.1403	CUTTER ASSY (UPPER)		
		X			647.1402	CUTTER ASSY (LOWER)		
			X		647.1401	CUTTER ASSY (UPPER)		
1404	1403	1402	1401	FIND #	PART #	DESCRIPTION	MATL	SPEC.

NEXT ASSY (\$)		ORIGINAL DATE		08-15-09	
647.1300		MOD. DATE		08-15-09	
		DRAWN BY		J. GARDINER	
		CHECKED BY		P. BRAVO	
		DRAWING APPROVAL		P. BRAVO	
		CONTRACT NO.			
		UNLESS OTHERWISE SPECIFIED			
		DIMENSIONS ARE IN INCHES			
		TOLERANCES ARE:			
		2 PLACE DECIMALS ± .01			
		3 PLACE DECIMALS ± .005			
		ANGLES ± .5°			
SIZE	CAGE CODE	DWG. NO.	REV.		
B	07M26	647.1400	B		
SCALE	NONE	SHEET	1 OF 1		

DART AEROSPACE
3030 ENTERPRISE CT., SUITE A
VISTA, CA 92081
(760) 724-5300

CUTTER ASSY